

Date: Monday, 11/05/2009 1:39:33 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WEARPLATE
<b>Job Number</b> : 47876	
<b>Estimate Number</b> : 13459	
<b>P.O. Number</b> :	<b>Part Number</b> : D38051
<b>This Issue</b> : 11/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3805 REV.A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 46623	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 25/05/2009 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>Julie Dawson</u>	
<b>Comment</b> : Est Rev:A 08-07-15 new issue DD verified by:EC Est Rev:B 08-07-30 redesign flat pattern DD verified by:EC Est Rev:C 08-09-23 redesign flat pattern DD verified by:EC Est Rev:D 09-03-04 rev.a as per dwg DD verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	M304S18GA	304/316 .050 Sheet
-----	-----------	--------------------



**Comment:** Qty.: 2.0110 sf(s)/Unit Total : 4.0219 sf(s)  
 304/316 .050 Sheet  
 batch: 108186 IB 9-5-20

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3805  
 Dwg Rev: A  
 Prog Rev: A

IB 9-5-20

(2)

2-Deburr if necessary IB 9-5-20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

IB 9-5-20

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

80915/21 (2)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



**Comment:** NC BRAKE  
 Form as per Dwg D3805 using Jigs DT8261 and DT8326

IB 09/05/25 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 11/05/2009 1:39:33 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 47876

Part Number: D38051

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/25 (2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Eric L

09/05/25 (2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/26

Job Completion



mf  
09-05-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8

7

6

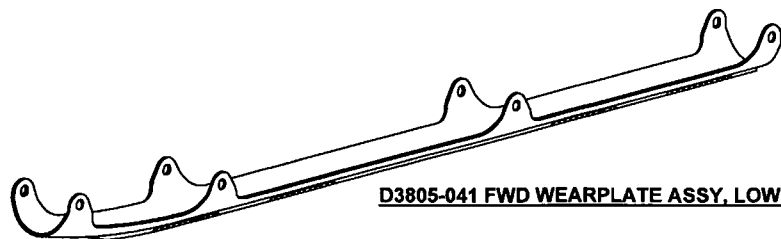
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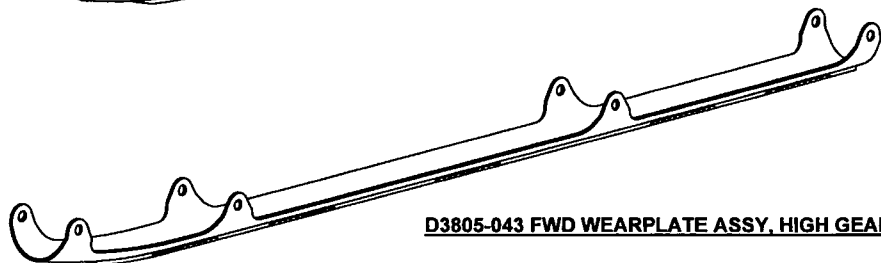
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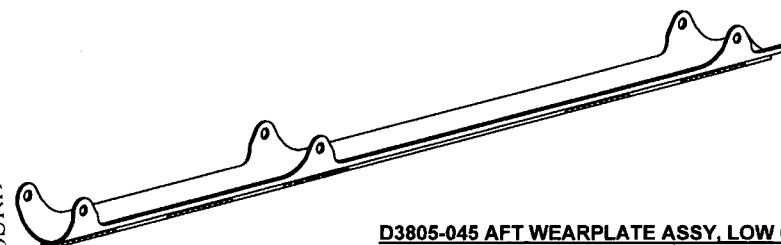
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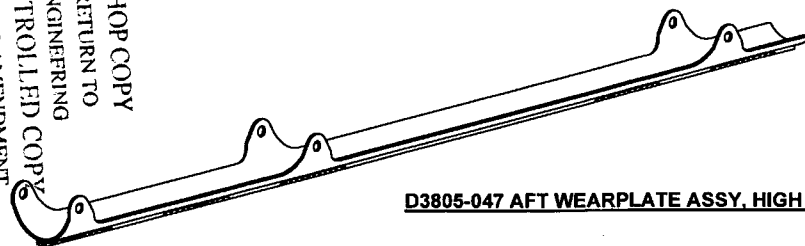
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

NO.

10/18/10

A

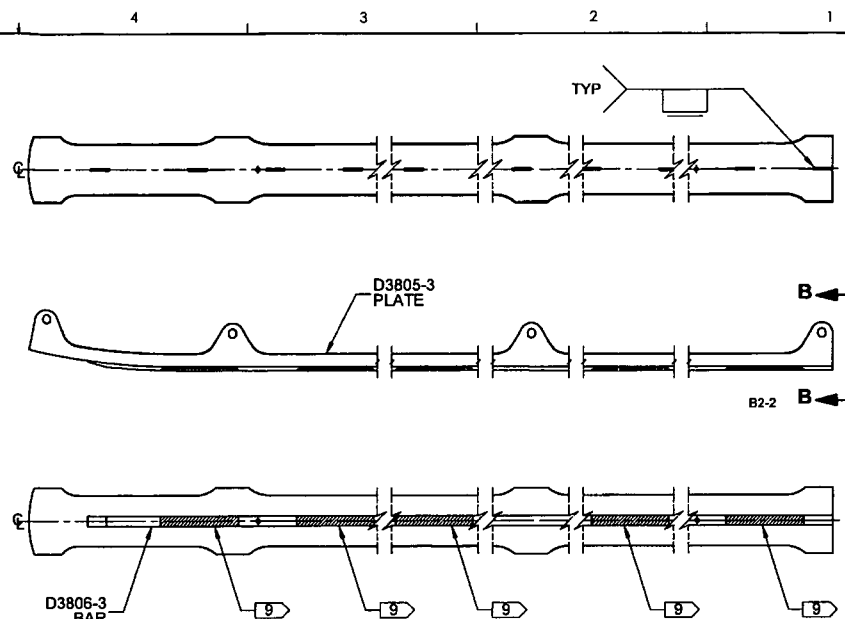
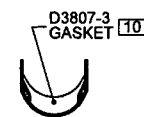
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ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

RELEASED  
09-03-03  
P4 ECN 09-538

A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.21		

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D3805	REV. A SHEET 1 OF 8
TITLE WEARPLATE ASSY	SCALE NTS
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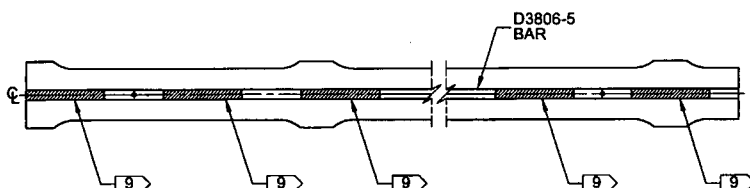
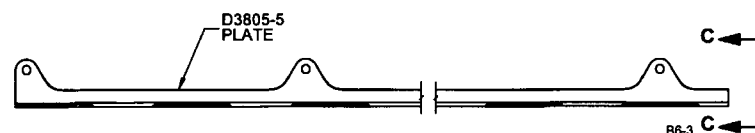
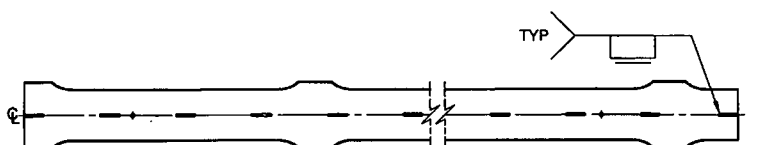
**D3805-043 FWD WEARPLATE ASSY, HIGH GEAR**

**VIEW B-B** C1-2

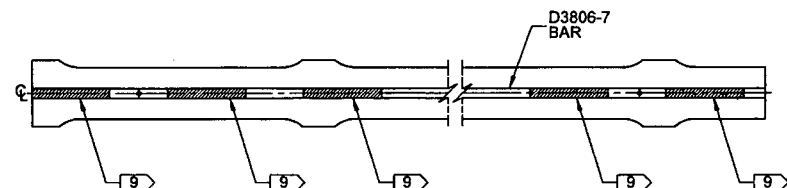
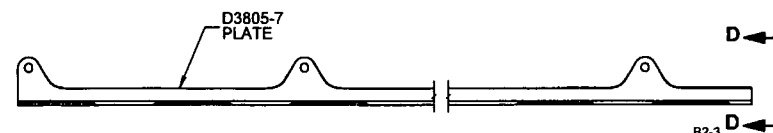
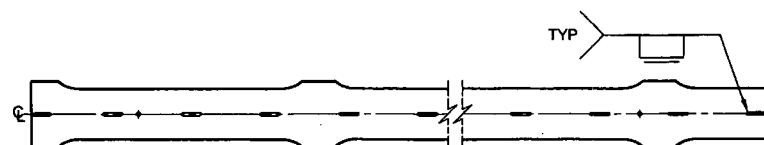
RELEASE  
CP 09.03.03

**NOTES:**  
1) MATERIAL: N/A  
2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: N/A  
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER  
7) WEIGHT: D3805-041 = 3.79 lbs; D3805-043 = 4.36 lbs  
8) WELDING: PER QSI 004  
9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES  
10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

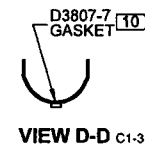
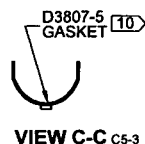
DESIGN	<i>JP</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA  DRAWING NO. <b>D3805</b>  TITLE <b>WEARPLATE ASSY</b>  COPYRIGHT © 2004 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND THE EXCLUSIVE PROPERTY OF DART AEROSPACE USA, INC. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	REV. #
DRAWN	<i>JLS</i>		SHEET 2 OF
CHECKED	<i>JLS</i>		SCALE
MFG. APPR.	<i>JS</i>		NTS
APPROVED	<i>JS</i>		
DE APPR.	<i>JS</i>		
DATE	<b>08.11.21</b>		



**D3805-045 AFT WEARPLATE ASSY.**



**D3805-047 AFT WEARPLATE ASSY.**



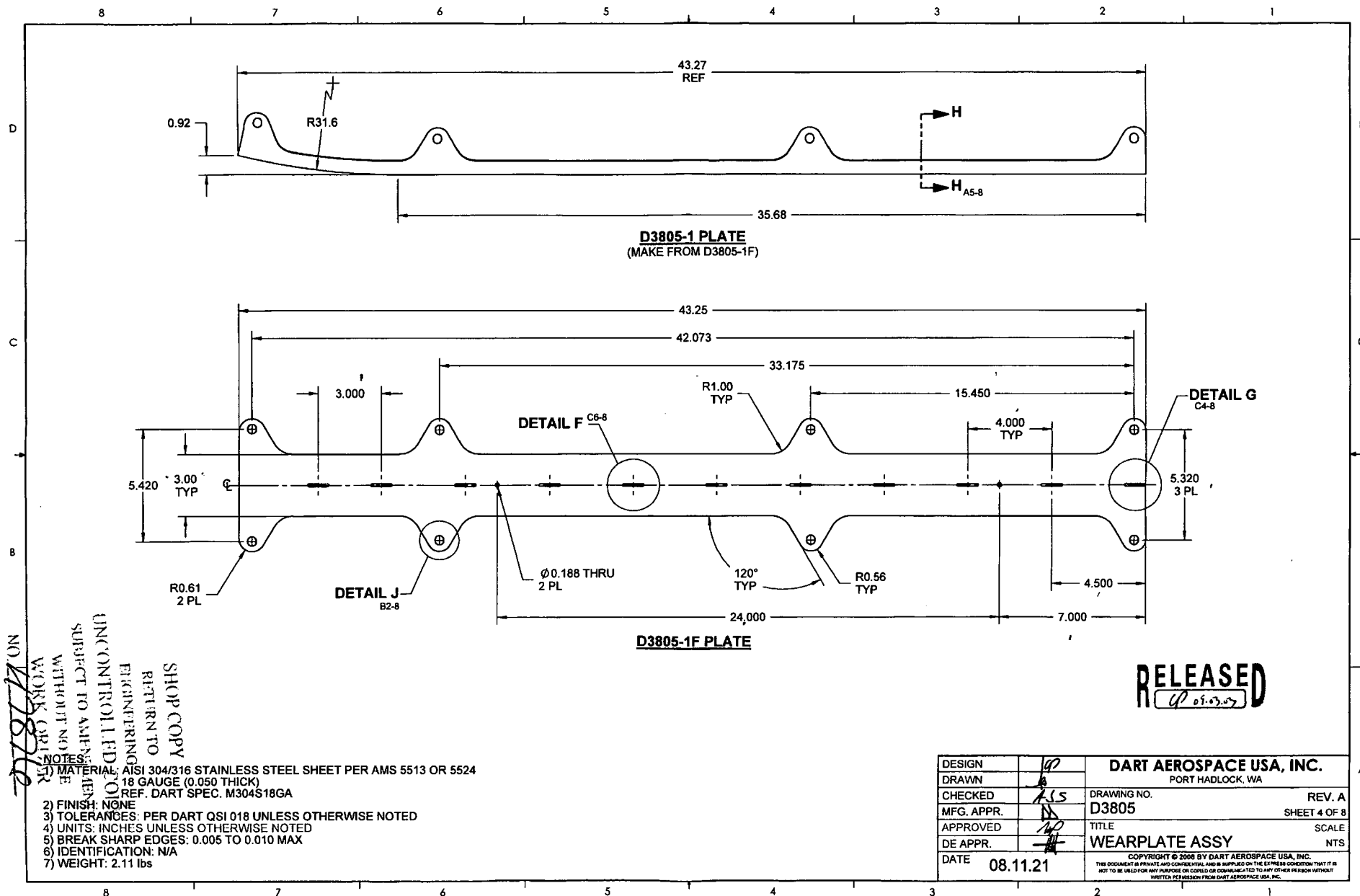
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- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: D3805-045 = 3.93 lbs; D3805-047 = 4.21 lbs
  - 8) WELDING: PER QSI 004
  - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
  - 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

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DRAWN	8	PORT HADLOCK, WA	
CHECKED	ALS	DRAWING NO.	REV. A
MFG. APPR.	11	<b>D3805</b>	SHEET 3 OF 8
APPROVED	11	TITLE	SCALE
DE APPR.	11	<b>WEARPLATE ASSY</b>	NTS
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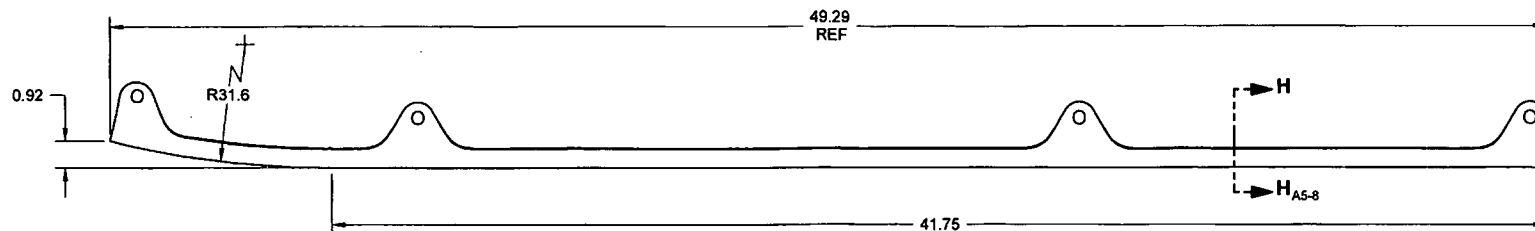


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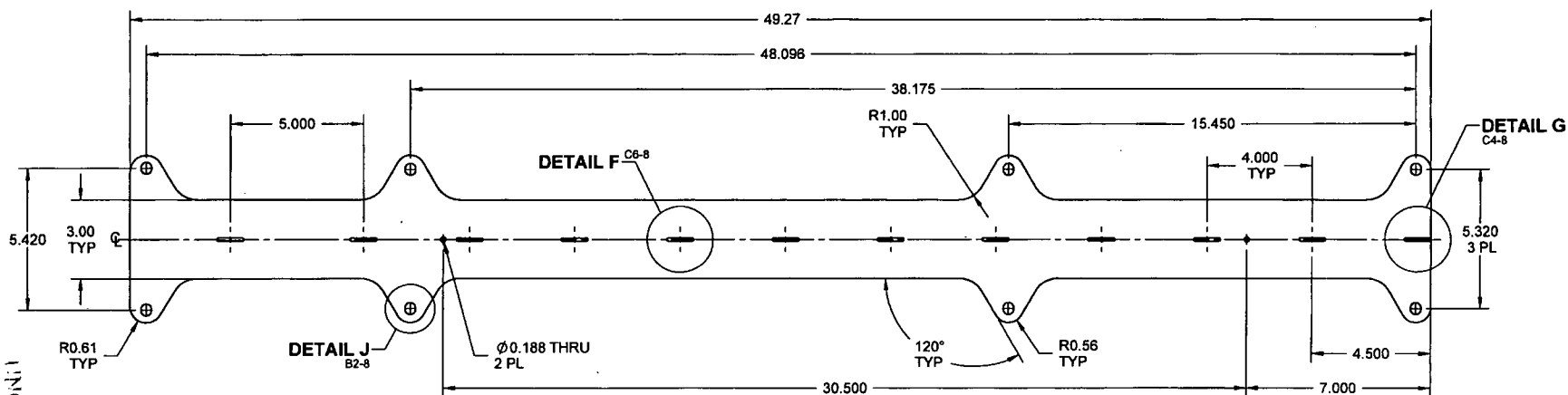
- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 2.11 lbs

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DRAWN	167	PORT HADLOCK, WA	
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MFG. APPR.	167	D3805	SHEET 4 OF 8
APPROVED	167	TITLE	SCALE
DE APPR.	167	WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1



**D3805-3 PLATE**  
(MAKE FROM D3805-3F)



**D3805-3F PLATE**

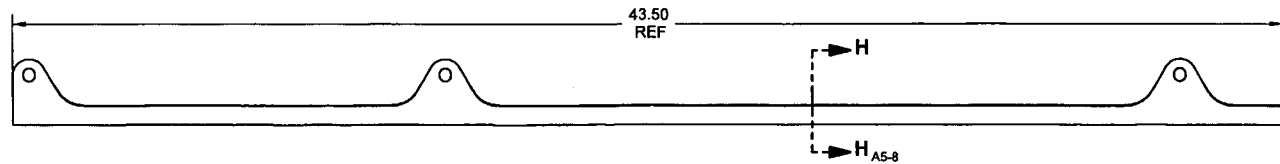
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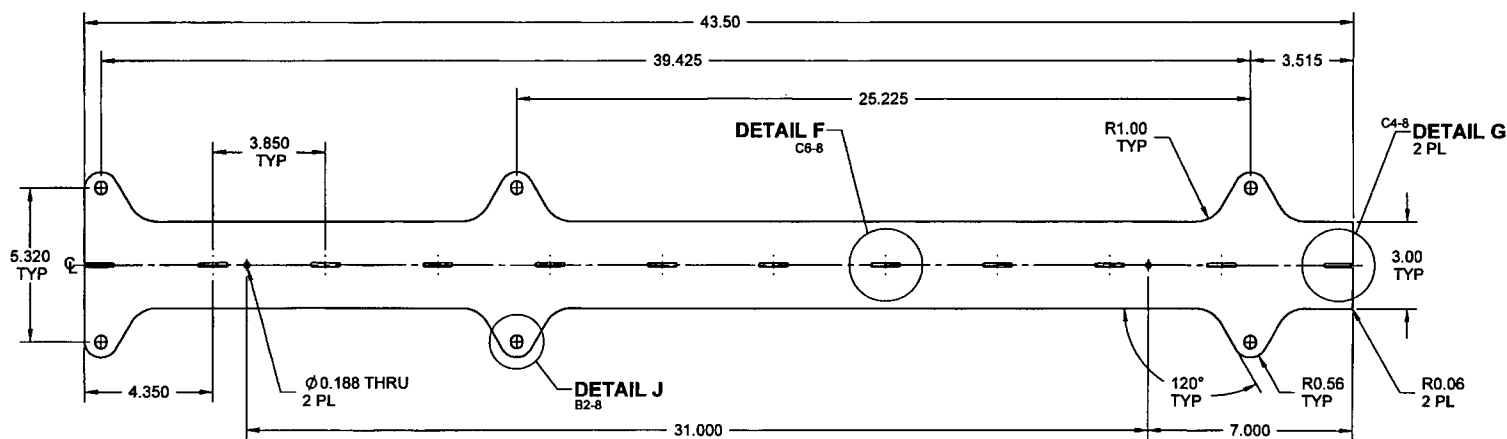
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18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 2.37 lbs

DESIGN	4P	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	8	DRAWING NO.	REV. A
CHECKED	7.5	<b>D3805</b>	SHEET 5 OF 8
MFG. APPR.	12	TITLE	SCALE
APPROVED	12	<b>WEARPLATE ASSY</b>	NTS
DE APPR.	12	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DATE	08.11.21		

8 7 6 5 4 3 2 1



**D3805-5 PLATE**  
(MAKE FROM D3805-5F)



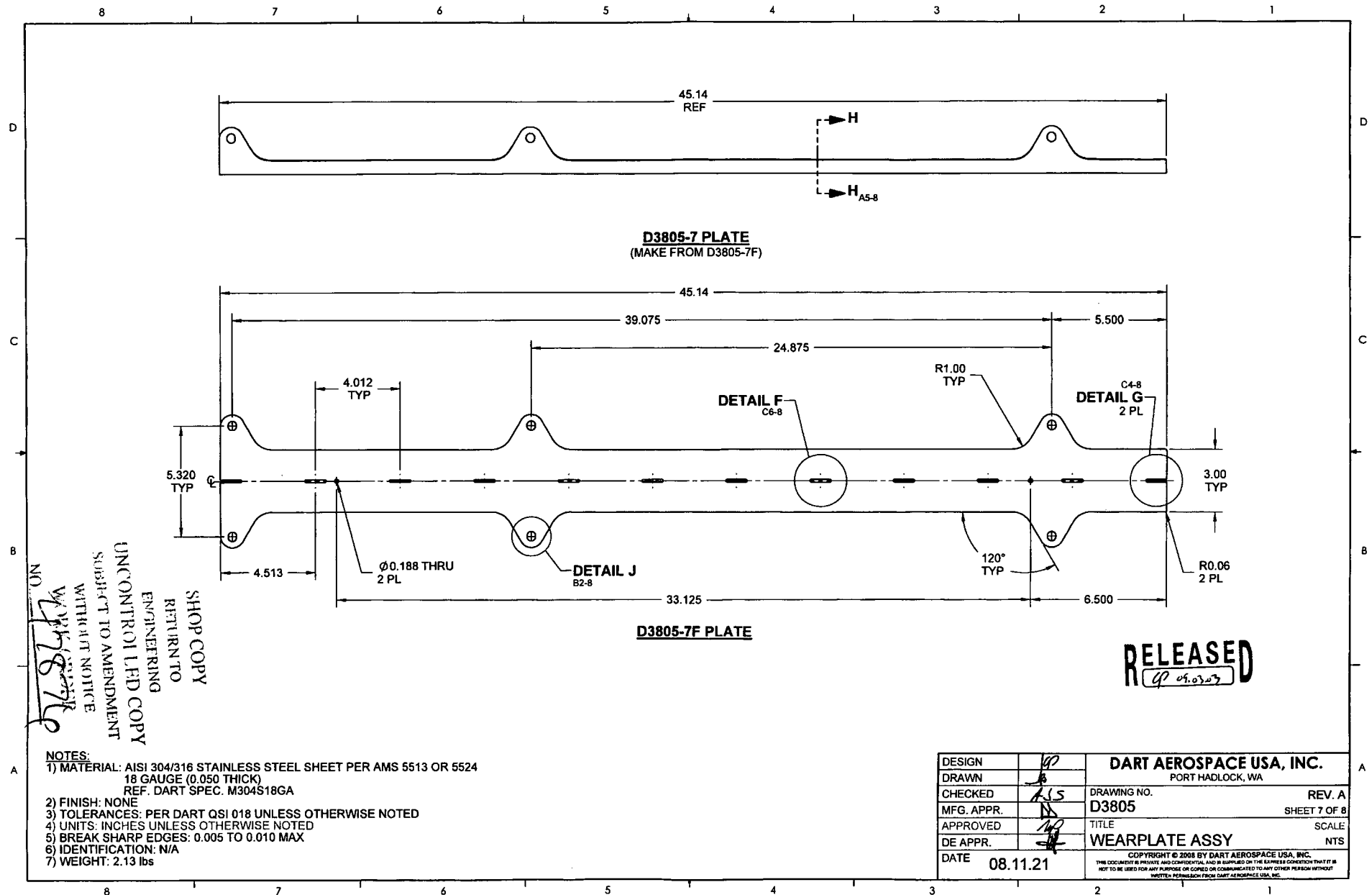
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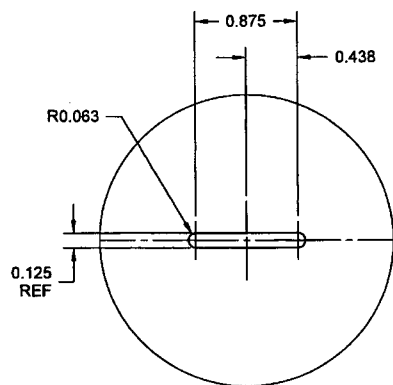
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- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 2.06 lbs

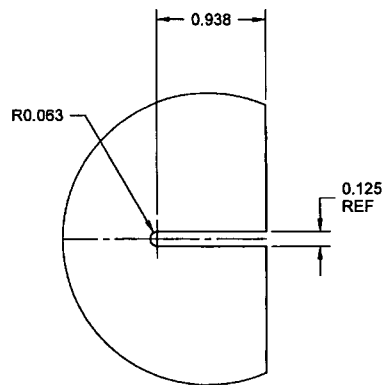
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DRAWN	AS	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	AS	D3805	SHEET 6 OF 8
APPROVED	AS	TITLE	SCALE
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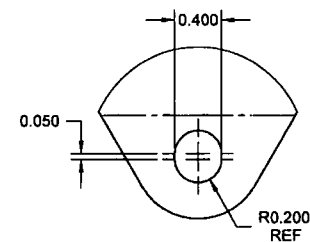
**DETAIL F**  
SLOT DETAIL TYP  
SCALE 4X

C5-4  
C5-5  
C4-6  
C4-7



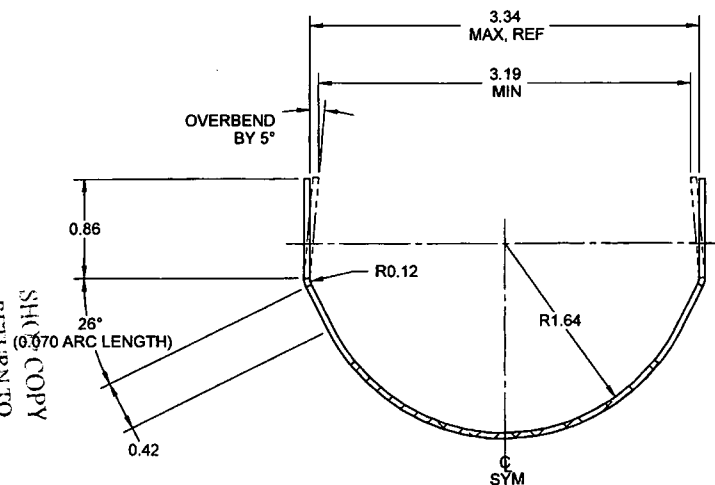
**DETAIL G**  
SLOT DETAIL TYP  
SCALE 4X

C1-4  
C1-5  
C1-6  
C2-7



**DETAIL J**  
SCALE 4X

B6-4  
B7-5  
B5-6  
B5-7



**SECTION H-H**  
SCALE 4X

D3-4  
D3-5  
D3-6  
D3-7

**RELEASED**  
4909.03.03

DESIGN	190	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	1	PORT HADLOCK, WA	
CHECKED	1.15	DRAWING NO.	REV. A
MFG. APPR.	1	D3805	SHEET 8 OF 8
APPROVED	1	TITLE	SCALE
DE APPR.	1	WEARPLATE ASSY	NTS
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